DEPARTMENT OF TRANSPORTATION

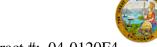
DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection

690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493

Bay Area Branch



Contract #: 04-0120F4

Cty: <u>SF/ALA</u> Rte: <u>80</u> PM: <u>13.2/13.9</u>

File #: 69.12

DAILY PROJECT JOURNAL

Prime Contractor: American Bridge/Fluor Enterprises, a JV Report No: DPJ-000333 **Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island Dated: 04-Oct-2007

Location: Changxing Island, Shanghai, China

Subm	ittals(New / Total):	CWR's: 0 / 4	HSR's: 0/3	NCR's: 1 / 10
Item	Title	Detail		
1	Nonconformance Reports	s (NCRs) NCR-01	NCR-011 QC failure to mark inspection performed on part	
2	Major component moven	nent 77m To	77m Tower Mock-up:	
		Installin	g Connection Plates on Skin Plates	
		89m To	wer Mock-up:	
		No weld	ling observed.	
		114m To	ower Mock-up:	
		Perform	Performing weld repairs to Skin Plate Stiffeners,	
		Welding	g of interior connection plates on Sk	kin Plates.
3	Meetings attended	_	with ABF and ZPMC at 1400 to di	scuss the schedule for the next
		two days		
		_	Bending of flange plates at Wuxi Boiler for the 77m and 89m Tower	
			ps is scheduled for Saturday, Octob	
			Non-Standard joint qualifications to	take place in Shanghai on
		•	y, October 6, 2007.	
			wer Mock-up:	
		Skin A a	awaiting CWR for 3rd time repair,	
		Installin	g Connection Plates on Skin Plate	D
		Diaphra	gms pending new flange plates from	n Wuxi Boiler.
		89m To	wer Mock-up:	
		Beveling	g Skin Plates A, B, D and E	
		Diaphra	gms pending new flange plates from	n Wuxi Boiler.
		114m To	ower Mock-up:	
		Perform	NDT and repairs to Skin Plate Stiff	feners.
4	Key conversations	Caltrans	met with ABF and ZPMC at 1300	to discuss issues related to
		fabricati	fabrication:	
		Caltrans	, ABF and ZPMC discussed the am	nount of rejections seen on the
		77m and	d 114m Tower Mock-ups. ABF sta	ted that of the 50 stiffeners
		.1.11	1 0 11 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1	

welded only 2 did not have rejections (this figure is worse than QA

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		estimates), and that ZPMC cannot continue welding with these rates. ABF	
		stated they would require ZPMC to demonstrate that they can perform	
		satisfactory stiffener to plate weld before they will be allowed to continue	
		fabrication. ABF is not convinced that the new welders are significantly	
		better than current welders, and ABF is requesting proof of improvement	
		prior to allowing ZPMC to proceed. ZPMC has considered performing the	
		stiffener to skin weld an inclined position to make the weld position flat, but	
		does not know how to maintain flatness of the member. ZPMC requested	
		guidance from Caltrans and ABF.	
		ABF asked ZPMC why they were welding new stiffeners after ABF gave	
		written notification that no new welds be perfored. ZPMC did not respond	
		in Caltrans presence.	
5	Other important observations	Caltrans met with ABF and ZPMC to discuss issues raised by Caltrans.	
		Discussed were the repair rate on the Tower Mock-ups, Closed-rib Weld	
		Trials, Closed-rib UT Procedure and OBG Bottom and Side Plate	
		Fabrication.	
6	Quality Assurance Inspectors per shift	3 Day Shift (Acuna, Franco, Viars)	
		3 Swing Shift (Berger, Dixon, Smith)	
		0 Graveyard Shift	
7	Logistics	ZPMC informed QA that they would not be welding during night shift	
		tonight.	
Inspected By: McClary, David		Quality Assurance Inspector	
Reviewed By: Lowry, Patrick		QA Reviewer	